



Dart Aerospace Ltd.
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Canada

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D5491-1
Job Sheet 181805



Part No: D5491-1

Job Qty: 8 ea

Part Name: Step Extrusion



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/9/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D5491 REV:B IPP REV:A 18.04.04 NEW ISSUE DD VERF:JFS IPP REV:B 18/08/02 AS PER DWG REV.B
JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	8/17/18	8/17/18	0.00	0.00	Start Up Large Fab-7		SL4
110	Large Fab	8 pcs	8/17/18	8/17/18	0.00	4.00	Large Fab 8		SL4 DAS
115	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC5		AUG 20 2018 38
120	Mill Conv	8 pcs	8/17/18	8/17/18	0.00	4.00	Mill Conv 2		9-89
124	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC2 Machining-5		18/9/18
128	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC8 Machining-5		B. 18-09-18
130	HandFinish	8 pcs	8/17/18	8/17/18	0.00	1.00	HandFinish 1		SA 18-09-18 DAS
150	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC7-5		SEP 18 2018 68
160	Packaging	8 pcs	8/17/18	8/17/18	0.00	0.00	Packaging3-2		SEP 19 2018 9-89
170	QC21-SA	8 Ea	8/17/18	8/17/18	0.00	0.00	QC21		21 SEP 20 2018

Part Op 110 - 1- CUT EXTRUSION AS PER DWG (Make sure ends are cut square) 2- DRILL HOLES USING DT10168 ON ONLY
Descriptions: ONE END AS PER DWG AND DEBURR. (Drill one hole at the time and put a drill bite in every holes before drilling the next) 3- C'SINK HOLES AS PER DWG

120 - 1- DRILL ALL FWD HOLES AS PER DWG 2- C'SINK HOLES AS PER DWG 3- MILL SLOT AS PER DWG. 4- DEBURR

160 - ***GA***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	4 Ea (.5 ea)	90-Start up Operation	S046116

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	4	3	0

Part Specifications

Specifications could not be found.

#5010

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Cross tube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐									
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Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval																									
Description Work Order Deviation		Disposition																										
		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																										
Root Cause <table style="width: 100%;"> <tr> <td style="width: 50%;">Environment ☐</td> <td style="width: 50%;">No Re-verification ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	Container No: S102474 Part: D5491 -- 1 Job No: 181805 Serial No/Batch: S102474 Revising: C Inspected: _____ Exp Date: _____ Instructions: Various SIC's Date: 06/25/18		
Environment ☐	No Re-verification ☐																											
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DART AEROSPACE LTD		Work Order: 181805
Description: Step Extrusion		Part Number: D5491-1
Inspection Dwg: Smeas P/U Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0,500	± 0,010	0,500	✓		Vernier JVDs	
1,500	"	1,499	✓		"	
1,000	"	0,992	✓		"	
1,000	"	1,002	✓		"	
0,989	"	0,999	✓		"	
43,81	± 0,030	43,820	✓		Tape	
0,653	± 0,010	0,652	✓		Vernier JVDs	
0,625	"	0,625	✓		"	
0,88	± 0,030	0,908	✓		"	
R0,19	"	0,180	✓		"	
35°	± 1/2°	35,4°	✓		angle finder	
0,629	± 0,010	0,630	✓		Vernier JVDs	
1,000	"	0,990	✓		"	
1,500	"	1,499	✓		"	
1,682	"	1,680	✓		"	
5,70	± 0,030	5,720	✓		"	
3,500	± 0,010	3,500	✓		"	
1,750	"	1,750	✓		"	
0,600	"	0,600	✓		"	
0,300	"	0,300	✓		"	
0,685	"	0,685	✓		"	
0,343	"	0,343	✓		"	
0,825	"	0,825	✓		"	
1,000	"	1,000	✓		"	
1,505	"	1,500	✓		"	
0,201 Ø	+0,005 -0,001	0,202	✓		"	
CSK 0,385	+0,006 -0,001	0,385	✓		"	
V 100°	± 1/2°	100°	✓		Vernier JVDs & C-Sink	
3,00 REF	± 0,030	3,00	✓		"	
2,50 REF	"	2,507	✓		"	

Measured by: <i>[Signature]</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 18/9/13	Date: 18-09-18	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

